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**Stop**

[REDACTED]

[illegible]

**Reference:**

Run Start

**Stop**

**Abstract**

[illegible]

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 ~~SHEAR~~

Shore 1/1

Shear	Water	Memo	0.00
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Blanks: 4.5" X 4.5"

as per

1

110	<i>Q2</i>	0.00
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HAAS CNC VERTICAL MACHINING #1

HAAS	Memo	0.00
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Item #	Description	Quantity	Unit Price	Total Price
1	H&H CNC vertical machine #1	1	\$10,000.00	\$10,000.00
2	Drill end mill accessories per U2757 step 1 proc.	1	\$1,000.00	\$1,000.00
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HAAS CNC vertical machine #1

11

100

120	QC <del>2</del> Inspect parts off machine FAI/FAIB	0.00
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QC	Memo	0.00
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### Quality Control

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2757 PAR #: NA Fault Category: Small Tabs NCR: Yes No DQA: ✓ Date: 11.05.13  
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: ✓ Date: 11/05/13

NCR: <u>68798</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
11/05/10	# 110	Found Qh X12 that have some of the .098" holes with a <del>hole</del> cut out on the end of them. R.C. less in less out this	11.05.10 GS1042	Scrap + Destroy and replace Qh X12 m# <u>112331</u>	13/15/11	11/05/14	11/05/10	11/05/10
		Depth is not set correctly machine mal function	11.05.10 GS1042	- Fix Program to ensure to stop this problem (Program is good)	11/05/10	11/05/14	11/05/10	11/05/10

NOTE: Date & initial all entries

**Work Order ID 68798**

Page 2

Thursday, April 21, 2011 8:05:07 AM

Item ID: D2757

Accept



Setup Start



Revision ID:

Stop



Item Name: Outer Doubler

Start Date: 4/20/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

12 BL 11-5-12

140

QC3- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Pro 7

150

Identify as per dwg &amp; Stock Location

0.00



Packaging

Memo

0.00

Packaging

11/5/12 S/P 12

Dart Aerospace Ltd

W/O: 68798		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
11/5/12	#140	Perm. Change change step to QC3 inspection	MJ	11/05/12 11.05.13	(12x)		S 11/05/12

Part No: D2757 PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

**Work Order ID 68798**

Page 3

Thursday, April 21, 2011 8:05:07 AM

Item ID: D2757

Accept



Setup Start



Revision ID:

Stop



Item Name: Outer Doubler

Start Date: 4/20/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 4/25/2011 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/12

MF

11-05/12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Thursday, April 21, 2011 8:05:15 AM

Page 1

Work Order ID: 68798

Parent Item: D2757

Parent Item Name: Outer Doubler




Start Date: 4/20/2011

Required Date: 4/25/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP B 98.11.25 New order of procedure DM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040  2024-T3 .040 sheet		Purchased	No			110	sf	91.5000	0.1458	1.841684			

B11-5-9

Location

Loc Qty

Loc Code

MAT022

91.5

112291

0.5

112331

27

113162

64

112331



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

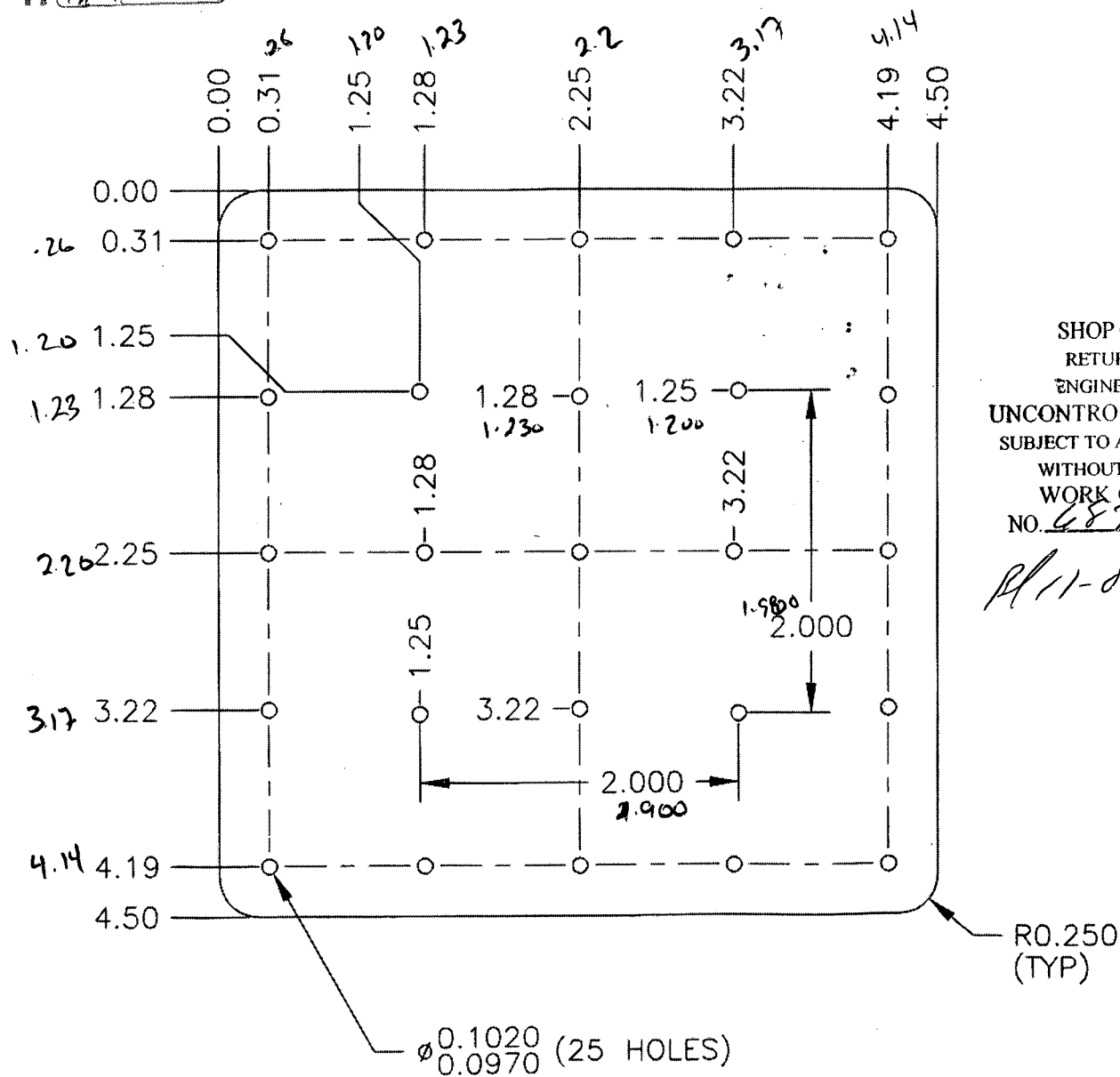
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries





RELEASED  
99/04/20 KE



SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 48798

PL 1-89-21

MATERIAL: 2024-T3 (QQ-A-250/5) 0.040 THICK  
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)							
DATE	STEP	Description of NC Section A	Corrective Action		Section B		Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

**NOTE:** Date & initial all entries



